



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D1038-58B
Job Sheet 168040



Part No: D1038-58B

Job Qty: 50 ea

Part Name: Avionics Fastener Rail



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/9/17

Job Tracking No:

Due Date: 11/9/17

Created By: Linda Lacelle

Type: Stock

Description:

Customer: Skyline Helicopter Technologies (CSKYL01)

195 Magill Street Lively, ON, P3Y 1K6 Canada ph:(705) 692-2900 fx:(705) 692-1265.

Note: DWG REV B IPP: E 03.05.02 Reformat; Added label KJ/RF IPP Rev:F 06-08-16 Updated Packaging
Procedures JLM IPP Rev:G 08-09-16 Added Folio # JLM Verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		11/7/17	0.00	0.00	Start up container		mark 17/12/09
110	Bandsaw	50 pcs		11/7/17	0.00	0.77	Bandsaw1		11
120	CNC Vertical Machining	50 pcs		11/7/17	0.03	8.26	HAAS 1		FM 17/12/15
130	QC	50 pcs		11/7/17	0.00	0.00	QC2		FM 17/12/15
140	QC	50 pcs		11/7/17	0.00	0.00	QC8		FM 17/12/15
150	Small Fab	50 pcs		11/8/17	0.00	12.25	Small Fab		F.F. DAS
160	QC	50 pcs		11/8/17	0.00	0.00	QC5		38
165	HandFinish	50 pcs		11/8/17	0.00	0.00	HandFinish2		9-89
170	Outsource	50 pcs		11/8/17	0.00	0.00	Outsource4		
180	Packaging	50 pcs		11/8/17	0.00	0.00	Packaging2		
190	QC	50 pcs		11/8/17	0.00	0.00	QC3		DAS
200	Small Fab	50 pcs		11/9/17	0.00	12.25	Small Fab		11 JAN 19 2018
210	QC	50 pcs		11/9/17	0.00	0.00	QC5		9-89 38
215	DC	50 pcs		11/9/17	0.00	0.00	DC		AT 3-86
220	Packaging	50 pcs		11/9/17	0.00	0.00	Packaging3		
230	QC21-FG	50 Ea		11/9/17	0.00	0.00	QC21		DAS

Part Op 110 - Cut extrusion D2023 to length 21.81" (+0.06/-0.00)

Descriptions: 120 - 1- Mill as per Folio FA783 Rev: _____ & Dwg D1038 Rev: _____ 2-Deburr per dwg D1038

150 - Deburr

165 - Clean rail from all marking using acid etch and scotch brite before sending to get anodize

170 - Issue P/O: _____ Black Anodize as per Dwg D1038

200 - 1-Stake .050 stainless steel wire per Dwg D1038-58 using DT8389 Batch: _____ 2-Grind wire flush and deburr 3-Clean

215 - Create white labels and bag them

220 - 1-Pack each fastener rail into a cardboard tube 2-Roll Part in foam . 3-Install red cap at each end and secure with tape. 4-Apply white labels to cardboard tubes 5-Identify and Stock Location: FG120A

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2023	95	1,896	0	0

137'

F140800

CSKYL01

Part Specifications

Specifications could not be found.

Plex 11/10/17 11:18 AM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

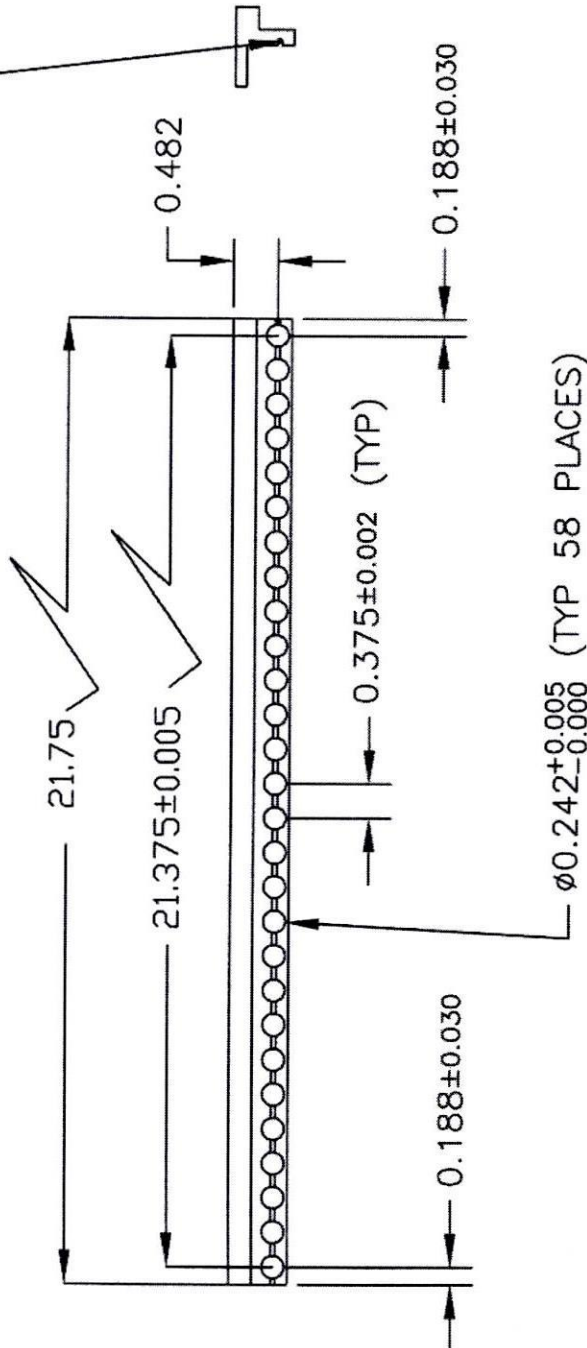


DESIGN 97	DRAWN BY A1	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED A1	APPROVED A1	DRAWING NO. D1038	REV. B SHEET 1 OF 1
DATE 05.02.02	TITLE 1/4 TURN FASTENER RAIL		SCALE NTS
-	91.05.05	NEW ISSUE	
A	04.05.14	UPDATE TOLERANCE	
B	05.02.02	REDRAWN, UPDATE NOTES	

RELEASED

05.03.31

STAKE $\phi 0.50$ TYPE 302 STAINLESS
STEEL WIRE FULL LENGTH
(REF DART SPEC M302SW.050)



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 168040 SB 17/01/10

D1038-58 1/4 TURN FASTENER RAIL

- 1) MAKE FROM D2023 EXTRUSION
- 2) FINISH: D1038-58 - NONE
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																								
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: SA Date: FEB 9 2018Work Order update only ☐

Work Order: <u>164040</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. <u>D1074-58B</u>		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. <u>18-6761</u>		Scrap ☒		Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: <u>17.12.05</u>		Step #: <u>120</u>		QTY Effective: <u>4</u>			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition			<u>PD 17.12.12</u>		
the part was install in the vise out of range of the origine zero R.C. training.				scrap destroy & replace			Completed By		
							<u>Mart</u> <u>17.12.12</u>		
							Lead hand / Supervisor Approval Verification		
							<u>PD 17-12-12</u>		
							QC / QA Coordinator Approval		
							<u>PD 17-12-12</u>		

Root Cause				FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐						
Design ☐	Operator ☒	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐						
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐						
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :									
Misidentified ☐	Past Due ☐										



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038682

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			is required							
20	167949	SWA10A-700	Wire Clamp : IPP Rev A 17.11.08 New issue DP Verify DD -Issue P/O to ATG: -HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 3 CLASS 2 -Certificate of Conformity is required	Firmed	1/17/18	20 pcs	0 pcs	20 pcs	\$7.75/pcs	\$155.00
21	168311	D2055	Clamp Issue P/O to ATG: ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2 C OF C IS REQUIRED	Firmed	1/17/18	5 pcs	0 pcs	5 pcs	\$6.20/pcs	\$31.00
22	168312	D2056	Bell Crank Assembly ISSUE P/O: _____ BLACK ANODIZE	Firmed	1/17/18	5 pcs	0 pcs	5 pcs	\$6.20/pcs	\$31.00
23	168040	D1038-58B	Avionics Fastener Rail Issue P/O: _____ Black Anodize as per Dwg D1038	Firmed	1/17/18	50 pcs	0 pcs	50 pcs	\$4.25/pcs	\$212.50
24	169062	RBW109-3101-58- 1-7	Handle -Issue P/O to ATG: -ANODIZE COLOR BLUE, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	1/17/18	1 pcs	0 pcs	1 pcs	\$51.00/pcs	\$51.00
25	169518	RBW109-3101-58- 2-7	Handle -Issue P/O to ATG: -ANODIZE COLOR BLUE, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	1/17/18	1 pcs	0 pcs	1 pcs	\$51.00/pcs	\$51.00
26	168827	RBW6705G02431- 3G-1	Lever Rigging Fork -Issue P/O to ATG: - ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2	Firmed	1/17/18	3 pcs	0 pcs	3 pcs	\$6.20/pcs	\$18.60



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914405

Date: 11-Jan-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
50 ea	Part: D1038-58B Avionics Fastener Rail Black Anodize per MIL-A-8625F, Type II, Class 2, .0004-.0010" (.4 - 1 mils). Job: 22211 Rev: B PO: PO038682 Line: 23		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>11/21/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: <u>[Signature]</u> A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			